

**Work Order ID 71029**

Tuesday, June 21, 2011 10:35:42 AM

ASAP



Page 1

Item ID: D3293-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/21/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*P*Date: *11-21*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3293

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293

☐ Dwg Rev: *A*☐ Prog Rev: *A*☐ 2-

Debur if necessary

*B11-7-4**(12)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B11-7-4*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Sub 6/21/11**(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- Deburr

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

12x Ø M-14/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, June 21, 2011 10:35:42 AM



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Item ID: D3293-1

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Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/21/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

170

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

180

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

Packaging

12x 1 M/L 4/07/05

12 d M/L 4/07/05

Pu/B/512

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 71029**

Tuesday, June 21, 2011 10:35:42 AM

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Revision ID:

Item Name: Doubler

Start Date: 6/21/2011 Start Qty: 12.00

Required Date: 6/27/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/7/5

MF 11-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 10:35:48 AM

Page 1

Work Order ID: 71029

Parent Item: D3293-1

Parent Item Name: Doubler



Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: ☐A☐04.08.24☐New issue☐KJ/JLM☐  
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.080		Purchased	No			100	sf	110.1000	1.8264	23.07032			
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B11-7-4

2024-T3 .080 sheet

Location

Loc Qty

Loc Code

MAT022

110.1

105411

6

109424

4

110347

0.5

110908

3

112331

3

113796

7

114025

17.2

116604

5.8

117392

63.6

118180

118180

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

71029  
399

DART AEROSPACE LTD		Work Order:	
Description: Doubler		Part Number:	D3293-1
Inspection Dwg: D3293	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.350	+/-0.010	.353	x		V B02	
0.650	+/-0.010	.657	x		V	
1.874	+/-0.010	1.876	x		V	
Ø0.141	+0.005/-0.001	.145	x		V	
Ø0.128	+0.005/-0.001	.132	x		V	
17.750	+/-0.010	17.750	x		T B01	
20.15	+/-0.030	20.15	x		T	
R0.350	+/-0.010	.356	x		R.G	
R0.312	+/-0.010	.312	2		R.G	
0.080	+/-0.010	.078	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-7-4	Date: 11/07/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	08.10.09	0.080 dimension added	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		TITLE	
04.06.28		04.06.28		DOUBLER	
A		NEW ISSUE		SHEET 1 OF 1	
				SCALE	
				1:3	

**D3293-1 DOUBLER**

MAKE PER DRAWING FILE "D3293-A1.DWG"

CHECK PER TEMPLATE D3293-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

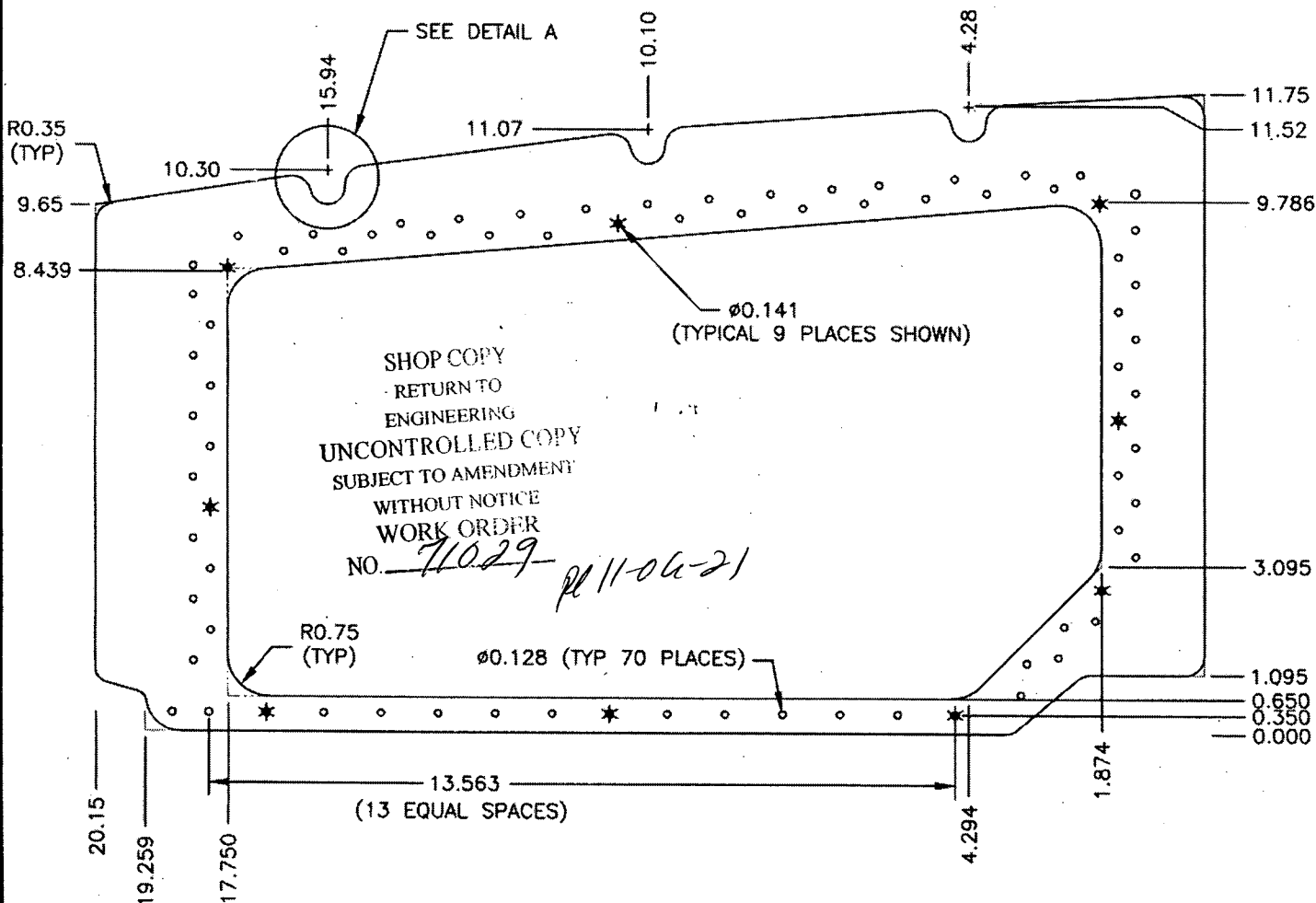
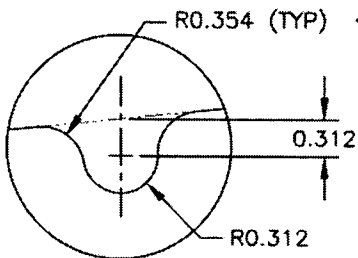
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER

DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12

**DETAIL A**  
SCALE 2:3



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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